

Date: Monday, 19/01/2009 2:07:13 PM
 User: Julie Dawson

Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET
 Job Number : 44908-2
 Estimate Number : 12806
 P.O. Number :
 This Issue : 19/01/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL / MED FAB
 Previous Run : 44663
 Part Number : D35702
 Drawing Number : D3570 REV.C
 Project Number : N/A
 Drawing Revision : C
 Material :
 Due Date : 10/02/2009 Qty: 2 Um: Each
 Written By :
 Checked & Approved By : JLO 09.01.20
 Comment : Est Rev:A New Issue 07-03.26 ec

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M6061T6S125 6061-T6 .125 Sheet



Comment: Qty.: 0.0746 sf(s)/Unit Total : 0.4473 sf(s)

6061-T6 .125 Sheet

Batch: 110405

IB 9-2-10

Grain must be Along 4.63**

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3570

Dwg Rev: B

Prog Rev: B

IB 9-2-10

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

S 09/02/10

(14)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Form as per Dwg D3570 Using DT8945

88

09/02/17

(14)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 44908

Part Number: D35702

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Cut excess materials per Dwg D3570.

3-Drill as per Dwg D3570 Using Dt8946

FF 09/02/17 (2)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 09/02/17 (2)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JS

09-02

(2K)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

1109648

START TIME:

1:09pm

OVEN TEMPERATURE:

320°F

FINISH TIME:

1:30pm

JS 09-02-17

x2

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/02/17

(2)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location:

09/02/17 (2)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/17

Job Completion



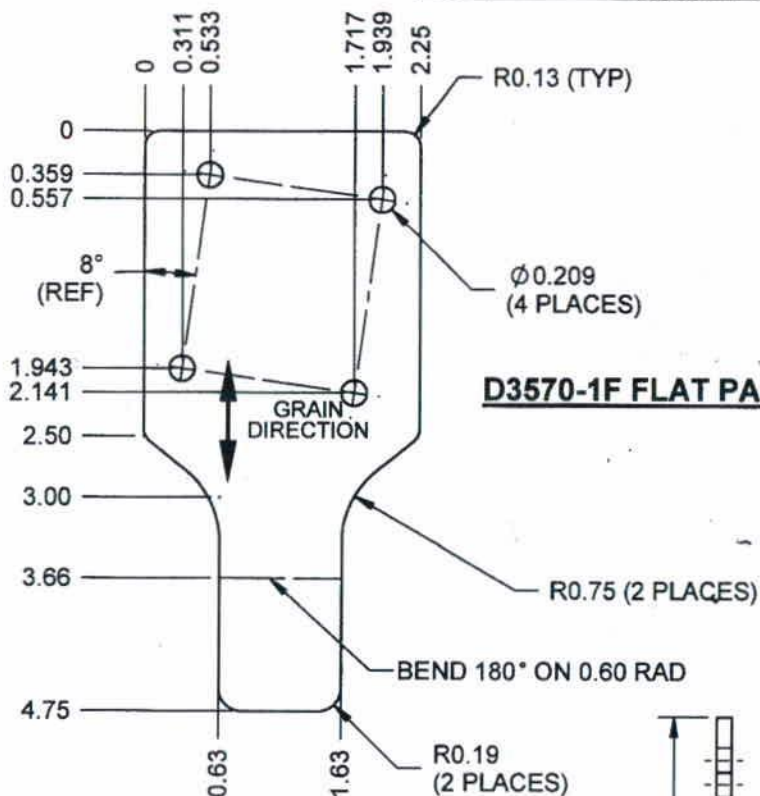
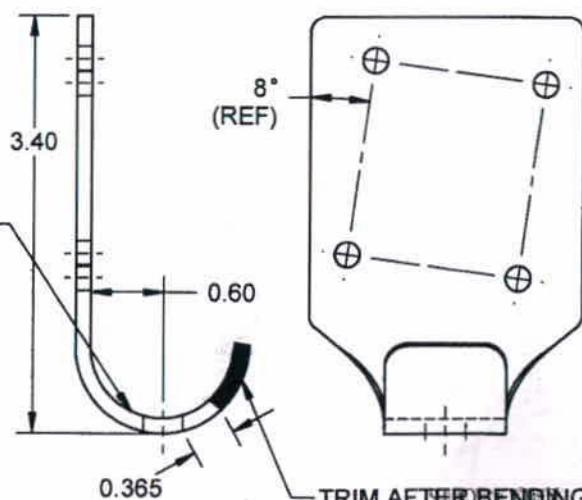
mf 09-02-17

FIRST ARTICLE INSPECTION CHECKLIST

Measured by: <i>IB</i>		Audited by: <i>J</i>		Prototype Approval: <i>1</i>	
Date: <i>9-2-10</i>		Date: <i>09/02/10</i>		Date: <i>1/1</i>	
Rev	Date	Change			Revised by
A		New Issue			KJ/JLM
					Approved

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3570	REV. C SHEET 1 OF 1
DATE 07.06.01	TITLE BRACKET	SCALE 2:3	
REV	DATE	DESCRIPTION	
A	07.02.07	NEW ISSUE	
B	07.04.16	CHANGE BEND RAD TO 0.60 FROM 0.50	
C	07.06.01	UPDATE DIMS FOR CLARITY	

**RELEASED**07.06.04 *H***D3570-1F FLAT PATTERN****D3570-1 BRACKET SHOWN**
(MAKE FROM D3570-1F)**D3570-2 BRACKET OPPOSITE**
(MAKE FROM D3570-1F)**NOTES:**

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM 0.125" THICK PER QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3570-1/-2" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 14908

COPYRIGHT © 2007 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.